

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023859**Date Inspected:** 18-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly open yard.

Segment:13AW

The following Non Destructive Testing (NDT) Inspection was carried out as per the AB/F submitted Notification No.05182011-1.

Ultrasonic Testing (UT)

This QA performed UT in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the weld between edge panel and side panel at cross beam side. Total number of welds UT tested: (1).The weld designations inspected was as follows:

1. SEG3013AA-106

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Segment: 13BW/CW

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) repair welding of weld joint identified as SEG3015K-209. Welder is identified as 040270. ZPMC QC is identified as Mr. Shi lei. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS): WPS-345-SMAW-1G (1F)-FCM-repair-1. The repair welding was being performed as per Welding Repair Report (WRR) No: B-WR21024.

SMAW repair welding of weld joint identified as SEG3015H-235. Welder is identified as 045196. ZPMC QC is identified as Mr. Shi lei. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-345-SMAW-4G (4F)-FCM-repair-1. The repair welding was being performed as per WRR No: B-WR21024.

SMAW welding of weld joint identified as SEG3014N-051. Welder is identified as 040614. ZPMC QC is identified as Mr. Shi lei. The welding variables recorded by QC personnel observed appeared to comply with WPS: B-P-2213-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as SA3122-004-008. Welder is identified as 045240. ZPMC QC is identified as Mr. Shi lei. The welding variables recorded by QC personnel observed appeared to comply with (WPS): WPS-B-T-2231-ESAB.

FCAW welding of weld joint identified as SA3122-016-008. Welder is identified as 066695. ZPMC QC is identified as Mr. Shi lei. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2231-ESAB.

AB/F QA Inspector's performing Magnetic Particle Testing for the deck panel base metal repaired areas adjacent to the splice weld joint. See attached photos for further details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
